Thursday, 5/10/2007 2:26:00 PM Kim Johnston **Process Sheet** : REPLACEMENT WINDOW ASSEMBLY : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 32285 Estimate Number : 11174 : D3290041 Part Number : MA P.O. Number S.O. No. : NV . D3290 REV B **Drawing Number** : 5/10/2007 This Issue Project Number : N/A : NC Prsht Rev. : SMALL /MED FAB **Drawing Revision** First issue : 28649 Material Previous Run Each : 6/6/2007 Qty: 6 Um: **Due Date** Written By Checked & Approved By Added Step 11 KJ/JLM Comment Est. C 06.05.09 Ecn 798 Now on Waterjet 06-06-16 JLM Est Rev:D **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: 5052-H32 .040 Sheet M5052H32S040 1.0 Comment: Qty.: 3.9375 sf(s)/Unit Total: 23.6250 sf(s) 5052-H32 .040 Sheet (M5052H32S040) 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3290 Prog Rev:__ ml07/06 2-Deburr if necessary 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 Comment: SECOND CHECK HAND FINISHING RESOURCE #1 5.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1

Page 1

Form: rorocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	TEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC:Inspector		
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		·								
		•								
							.*			

Part No: D3290-041 PAR #: HA Fault Category: Food Fas' AS' MED TORE

NCR Yes No DQA:

A: Date: 076763

QA: N/C Closed: Date: 07,07,23

WORK ORDER NON-CONFORMANCE (NCR)

NCR: 3	2285	VV	ORK OR	DER NON-CONFORMANCI	E (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Initial Action Description Sign &		Verification Section C	Approval Chief Eng	Approval QC Inspector
07/06/12	2.0	One part was Scrap because the jet offset had to be change to 0.017 instead of the regular Offset of 0.015		Scrup, destroy, replace	SAV 07/06/13	5n 07/06/18	Reside	50 07/d6/18
					*			

NOTE: Date & initial all entries

[kursday, 5/10/2007 2:26:00 PM Date: ⊀im Johnston Uger: **Process Sheet** Drawing Name: REPLACEMENT WINDOW ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3290041 Job Number: 32285 Job Number: Description: Seq. #: Machine Or Operation: POWDER COATING 6.0 POWDER COATING 1104144 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 7.0 POWDER COAT/CHEMICAL CONVERSION D2126 8.0 Comment: Qty.: 6.5000 f(s)/Unit Total: 39.0000 f(s) Locking Seal Pick: Qty Part Number Description D2126-0780 Locking Seal 1 9.0 D32901 Comment: Qty.: 0.0000 Each(s) 0.0000 Each(s)/Unit ,Total: Window Frame Pick: Qty Part Number Description D3290-1 Window Frame D32903 10.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Window Pick: D32366 Qty Part Number Description D3290-3 Window SMALL & MEDIUM FAB RESOURCE 1 11.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3290 SAD Clean D3290-041 and place in plastic wrap

Dart Ae	rospace L	td									
W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			······································								
Part No	i	PAR #:	Fault Category:	NCR: Yes	No DQ	A :	Date:				
				QA:	N/C Closed	d:	Date:				
NCR:		WO	RK ORDER NON-CONF	ORMANCE (NC	R)						
		Description of NC	Corrective Action	Section B	Vorific	ation	Approval	Approval			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector		
						1	ì	1		

NOTE: Date & initial all entries

Thursday, 5/10/2007 2:26:00 PM Date: - →Kim Johnston User: **Process Sheet** Drawing Name: REPLACEMENT WINDOW ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3290041 Job Number: 32285 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 12.0 QC5 (t Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 13.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

14.0 QC21

07.01.16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-07-16

Dart Ae	rospace L	.ta									
W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE By				Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto			
							:				
Part No	•	PAR #: I	Fault Category:	NCR: Yes	s No DQA	:	Date:				
		4.5		QA:	N/C Closed	:	_ Date: _				
NCR:		WOF	RK ORDER NON-CONF	ORMANCE (NO	R)						
		Description of NC	Corrective Action	Section B	Verifics	ation	Approval	Approva			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Approval	Approval			
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector			
		•									
								t :			
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32285
Description: Window Frame	Part Number:	D3290-1
Inspection Dwg: D3290 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.000	+/-0.010	29,000			MT	
14.000	+/-0.010	14,000	/		MT	
Ø0.171	+0.005/-0.001	\$0.174			Vern	
- 13.61	+/-0.030					NA 12
1.50	+/-0.030	1.50			Vern	,
1.11	+/-0.030	1.10	/		Vern	
10.10	+/-0.030	10-12			Vern/M	1-T
18.50	+/-0.030	18.50			Vern	
0.040	+/-0.010	0.039	1		Vern	
R3.00	+/-0.030	R3.00			R-L	
R4.50	+/-0.030	R4,50			R-6	
Ø0.257	+0.006/-0.001	\$0.260			Vern	
		·		****		
				,		
3						
				-		

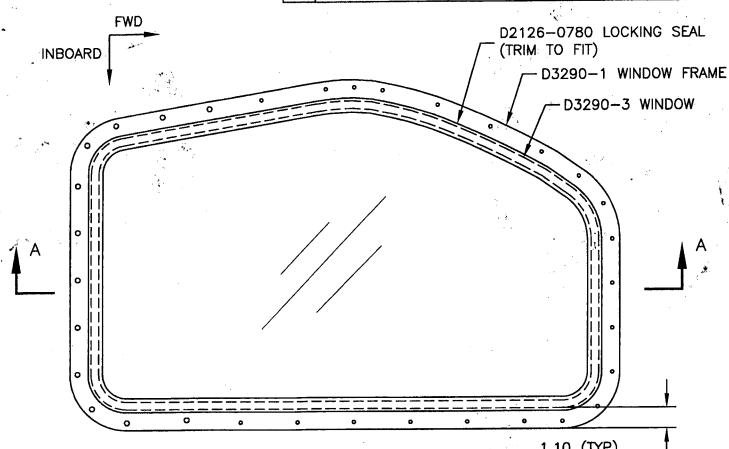
Measured by:	SAN	Audited by:	Prototype Approval:	N/A
Date:	07/06/13	Date: 07/06/18	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	06.09.19	New Issue	P/O D3290-041	KJ/JLM	

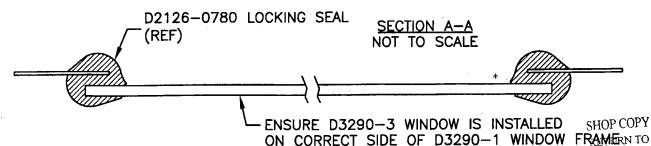




		4	1				
DESIG	RF	DRAWN	BY	DART AEROS HAWKESBURY, ONTA	PACE ARIO, CANADA	LTD	
CHECK	KED .1	APPROV	ED /	DRAWING NO.			REV. B
	#	,	#	D3290	Ψ.	SHEET	1 OF 3
DATE	<u></u>	·		TITLE			SCALE
06.0	04.20		`	REPLACEMENT WINDOW	ASSEMB	LY	1:5
Α		04.0	6.14	NEW ISSUE			
R		06.0	14.20	UPDATE MATERIAL PER	NCR 0	29	



1.10 (TYP) DIST. FROM FRAME EDGE TO WINDOW



D3290-041

NOTES

1) ALL DIMENSIONS ARE IN INCHES

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

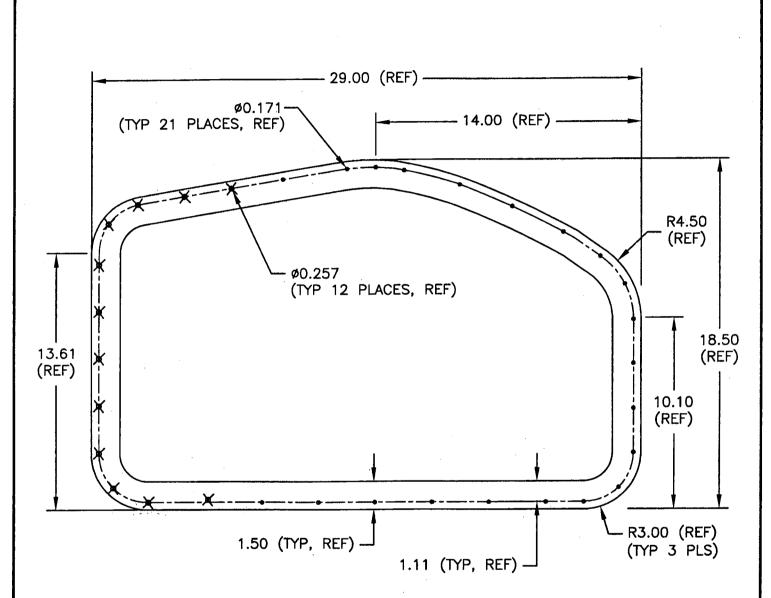
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design RF	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
横	#	D3290 SHEET	2 OF 3
DATE	<u> </u>	TITLE	SCALE
06.04.20		REPLACEMENT WINDOW ASSEMBLY	1:5



D3290-1 FRAME

D3290-1

1) MACHINE PER DRAWING FILE "D3290-A2.DWG"

2) MATERIAL: 5052-H32 (QQ-A-250/8) SHEET 0.040 THICK

3) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FEREASER 06 04.20 ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

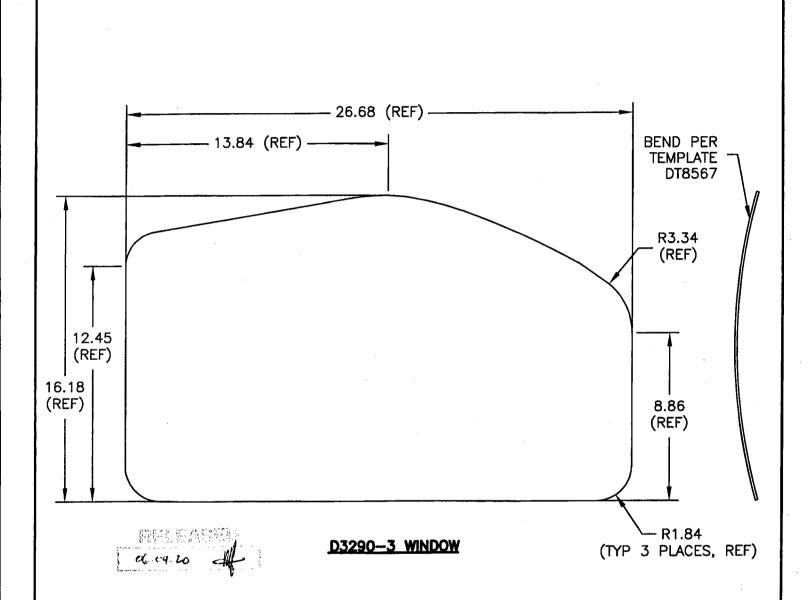
WITHOUT NOTICE WORK ORDER

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DESIGN RF	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D
CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3290 sh	EET 3 OF 3
DATE		TITLE	SCALE
06.04.20		REPLACEMENT WINDOW ASSEMBLY	1:5



D3290-3

1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425

OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER

LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

SHOP COPY

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT NOTICE NO 3228

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) CHECK PART USING DT3290-3T1

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